

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022649**Date Inspected:** 29-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

This Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection, non-destructive testing and painting of the Travelers. Upon the arrival of the QA Inspector, the following observations were made:

**Traveler Test Rack**

This QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

**SAS-WB Traveler**

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID #3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Jose Miranda (WID #3083) continuing to perform Flux Core Arc Welding (FCAW) tacking and fitting activities on the SAS-WB Traveler suspension arm assemblies. This QA Inspector observed Mr. Miranda performing the activities on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production personnel Mr. Cesar Canales and Mr. Raymundo Anaya continuing to perform layout and fitting activities for the SAS-WB frame assemblies.

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### E2/E3-EB Traveler

This QA Inspector observed WMI production welder Mr. Jose Delgadillo (WID #3193) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB Traveler suspension arm assemblies. This QA Inspector observed Mr. Delgadillo performing the FCAW welding activities on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production personnel utilizing two overhead shop bay cranes, chains and shackles to lift the E2/E3-EB Traveler. This QA Inspector had been previously informed by shop superintendent Mr. George Grayum that the Traveler will be staged in the outside sandblast and primer area, on this date. Initially, this QA Inspector observed that the chains and shackles were being attached to the primary suspension lift plates. Once attached, this QA Inspector observed 2 WMI personnel utilizing the hand held crane controllers to raise the Traveler off of the fabrication stands. This QA Inspector then observed WMI personnel utilize the two cranes to strategically maneuver the Traveler to the west end of the bay #4. Near the end of bay #4, this QA Inspector then observed WMI personnel utilize the cranes to lower the Traveler and place on the floor. Once placed, this QA Inspector then observed the two overhead shop bay cranes in bay #6 being attached to the previous placed chains and shackles. This QA Inspector then observed WMI personnel raise the Traveler and continue moving in the west direction, in the bay. Once the Traveler reached the end of the bay, this QA Inspector observed WMI personnel lower the Traveler and detach one of the cranes from the chains and shackles. This QA Inspector then observed that an outside boom crane had been previously set up to then lift the Traveler, from this point. This QA Inspector then observed Hydraulic Cranes LLC personnel attach the boom crane hook to one end of the previously placed chains and shackles. Once placed, this QA Inspector observed Hydraulic Cranes and WMI personnel strategically lift the Traveler and maneuver in the west direction, outside near the sandblast and primer area.

At the end of the shift, this QA Inspector observed that the Traveler had not been placed on the previously placed stands in the sandblast and primer area and was informed by WMI personnel that these activities will continue on the following day, 3/30/11.

See attached pictures below.

This QA Inspector randomly observed that Smith Emery QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

### Paint: SAS and E2/E3-EB Travelers

This QA Inspector observed that RPI Coating personnel were not present and no painting activities were performed.

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This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.



## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

**Inspected By:** Vance, Sean

Quality Assurance Inspector

**Reviewed By:** Edmondson, Fred

QA Reviewer